

Work Order ID 57886

Monday, April 19, 2010 3:35:04 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/4/20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

5/10/05/03

for BG 10/04/29

B57886

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ ☐ ☐ Aluminum Rod

M113207

BE 10/04/21

10-Grind welds flush as per Dwg D2750

DP

10-4-21

H 6/4/21

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

4/21/21

120

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/21



QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

8/10/21



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 - - HAW
10-4-21

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

DP 10-4-21

QC

Memo

0.00

Quality Control

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: M112429
exp. date: 10-8-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M113207

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750



10-4-21



10-4-23

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NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

12-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Sidel 23

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sidel 23

⑩

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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Stop

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

① 104-20

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:30 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:00 AM

= 2nd 10/04/27

1 8

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024.

= 7 m. 10/04/27

①X

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Stop

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinish

HandFinishing

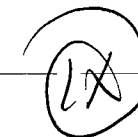
Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

= 7 m. h 10/04/27



230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M112429

EXP DATE: 10/08

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M114189

5-Coat all exposed fasteners with "LPS Procyon"

batch: N/A

104251

m-h 10/04/27

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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

8 1064/27



QC

Memo

0.00

Quality Control



250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-4-29 SF

260

QC4- 100% Inspect kits for completeness

0.00



QC

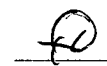
Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

8 1065/03



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Customer:

Reference:

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
	Packaging								
	Memo	0.00							
	Package as per PPP D350-636-011								
280	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

Ran H

10-5-11

10/05/04

BS 10-5-04

Picklist Print

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Work Order ID: 57886

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No 230 Each 188.0000 8.0000



O-Ring, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

188

55546 ✓

188

Manufactured No

110

Each

40.0000

1.0000

D2744



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

40

47488

21

51922

19

Manufactured No

110

Each

3.0000

1.0000

D2600-3-BENT



Extrusion Bent

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

3

55462

3

8x m-l 10/04/27

1 4/10/4/21

B 57338

① 4/10/4/21

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 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 130.0000 8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 130

50281 50

52310 80

D2739 Manufactured No 160 Each 7.0000 1.0000



350 I Beam

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 7

55986 1

56060 6

D3490-3 Manufactured No 160 Each 40.0000 4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 40

55010 40

8 BE 4/10/04/22

DP 10-4-21

4 BE 10/04/22

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Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3490-1

Manufactured No

160

Each

73.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

73

51932

8

57723

65

4 OG 10/04/22

ALS4-1032-225

Purchased

No

220

Each

7,689.000

38.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

PK011

7689

110768 ✓

7689

38x m-l
W/04/27

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Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3492-041

Manufactured No

230

Each

82.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

55446 ✓

42

Main Warehouse

FP031

40

57517

40

8X m.k 10/04/27

D3793-3

Manufactured No

230

Each

10.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

10

55458 ✓

10

1X m.k 10/04/27

AN8C35A

Purchased No

230

Each

19.0000

1.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

19

110847 ✓

19

1X m.k 10/04/27

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Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3793-1

Manufactured No

230

Each

14.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP18

14

51597

2

56300 ✓

12

D3488-041

Manufactured No

230

Each

34.0000

1.0000



Blade Fitting Assembly, LH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

24

47348 ✓

4

53915

20

Main Warehouse

FP007

10

56052

10

10/04/27

IX m-k

IX m-k 10/04/27

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Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3794-3

Manufactured No

230

Each

27.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

4

51907 ✓

4

Main Warehouse

FP18

23

56066

23

AN6C44A

Purchased

No

230

Each

53.0000

4.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST344

51

111605 ✓

1

111649

50

1x m-d 10/04/27

4x m-d 10/04/27

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Required Qty: 1.00

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IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

MS21083C8 Purchased No 230 Each 50.0000 1.0000



NUT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST303 50

113845 ✓ 50

D3536-25 Manufactured No 230 Each 10.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP10 10

54479 ✓ 10

D3631-1 Manufactured No 230 Each 302.0000 8.0000



Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST076 302

52693 ✓ 302

1x m-h 10/04/27

1x m-h 10/04/27

8x m-h 10/04/27

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IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3791-1

Manufactured No

230

Each

18.0000

1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

55457

7

Main Warehouse

FP17

11

56299 ✓

11

AN960C10L

Purchased No

230

Each

0.0000

38.0000



NAS1149C033QR

M114341



washer

D2745

Manufactured No

230

Each

150.0000

8.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST023

150

52311 ✓

150

10/04/27

1x m-l

38x m-l 10/04/27

8x m-l 10/04/27

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IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

AN3CSA

Purchased

No

230

Each

883.0000

34.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST350

500

114330

500

Main Warehouse

ST351

383

113121

53

114056

179

114108

51

114181

100

34x m-l 10/04/27

D3537-1

Manufactured

No

230

Each

63.0000

3.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

9

55465

9

Main Warehouse

FP17

54

57510

54

3x m-l 10/04/27

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IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

AN960C816L

Purchased No

230

Each

146.0000 1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

146

110584

100

111424

46

D3492-043

Manufactured No

230

Each

82.0000 8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

54682

42

Main Warehouse

FP013

40

57519

40

1x m-l 10/04/27

8x m-l 10/04/27

Picklist Print

Monday, April 19, 2010 3:35:04 PM

Work Order ID: 57886



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

AN3C6A Purchased No 230 Each 679.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST351 679

111982 ✓ 679

NAS1611-013 Purchased No 230 Each 41.0000 8.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 41

113743 ✓ 41

D3535-25 Manufactured No 230 Each 16.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 16

56065 4

56839 ✓ 12

4x m-l 10/04/27

8x m-l 10/04/27

1x m-l 10/04/27

Monday, April 19, 2010 3:35:04 PM

Shop Packet Print

Picklist Print

Monday, April 19, 2010 3:35:04 PM

Work Order ID: 57886



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

D3794-1

Manufactured No

230

Each

19.0000

1.0000



Gasket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

55459

7

Main Warehouse

FP014

12

57537 ✓

12

MS21043-6

Purchased

No

230

Each

878.0000

4.0000



NUT



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST301

878

112314

878

D3493-1

Manufactured

No

260

Each

19.0000

2.0000



Washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST224

19

47710

19

1x m-k w/04/27

4x M 10/04/29

10-4-29 SA

2

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• Picklist Print

Monday, April 19, 2010 3:35:04 PM

Work Order ID: 57886



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21083C8



NUT

Purchased No 260 Each 50.0000 2.0000



10-21-27 8

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST303 50

113845 50

AN8C21A



BOLT

Purchased No 260 Each 99.0000 2.0000



2
 10-4-27 5

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST345 99

111605 49

113558 50

AN960C816L



WASHER

Purchased No 260 Each 146.0000 2.0000



10-4-29 5

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST348 146

110584 100

111424 46

2

Picklist Print

Monday, April 19, 2010 3:35:04 PM

Work Order ID: 57886



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3672-1 Manufactured No 230 Each 1,589.000 4.0000



Phenolic Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST077 1589

47628 ✓ 89

51674 500

52505 1000

4x M-L 10/04/27

D2741 Manufactured No 260 Each 43.0000 1.0000



Blade, 350 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST466 43

51931 11

55905 32

1

D3532-1 Manufactured No 260 Each 51.0000 2.0000



Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST068 51

52321 51

2

10-4-29 SD

Picklist Print

Page 15

Monday, April 19, 2010 3:35:04 PM

Work Order ID: 57886



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3672-13

Purchased

No

260

Each

920.0000 2.0000



Phenolic Washer



10-4-29 SJ

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

920

54363

920

2

Monday, April 19, 2010 3:35:04 PM

Shop Packet Print

Page 15

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALONG ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCVON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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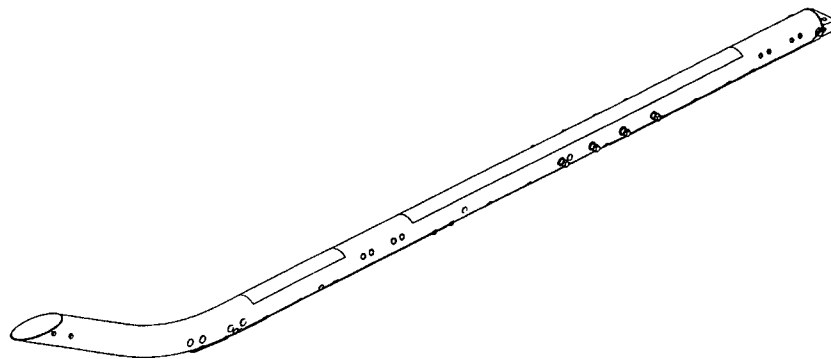
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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

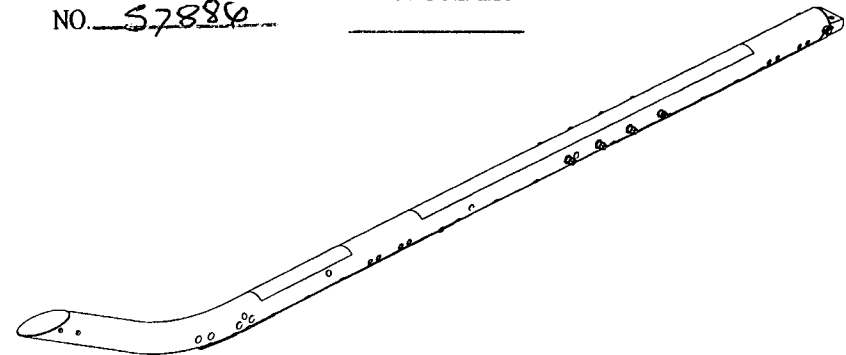
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TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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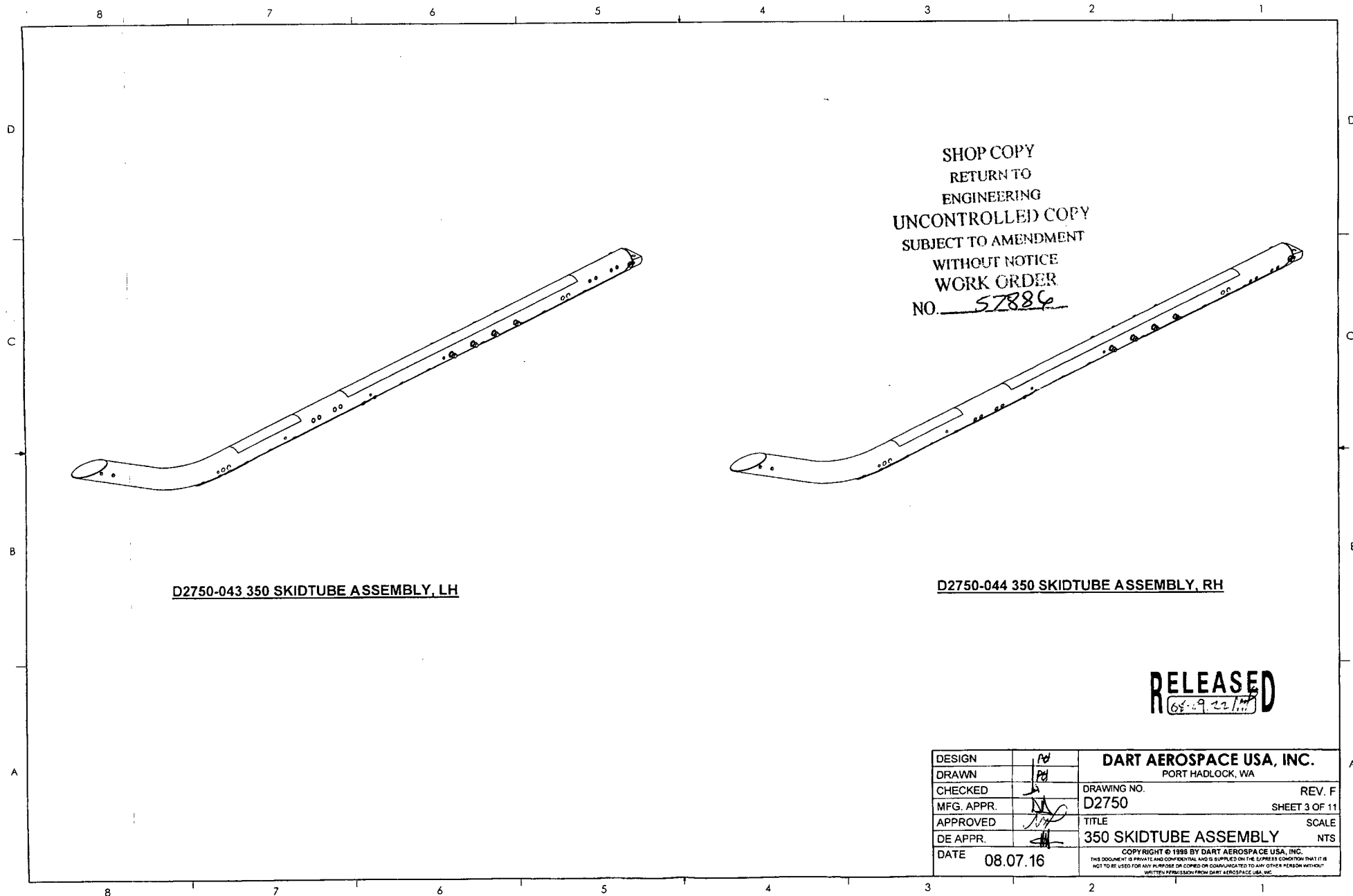
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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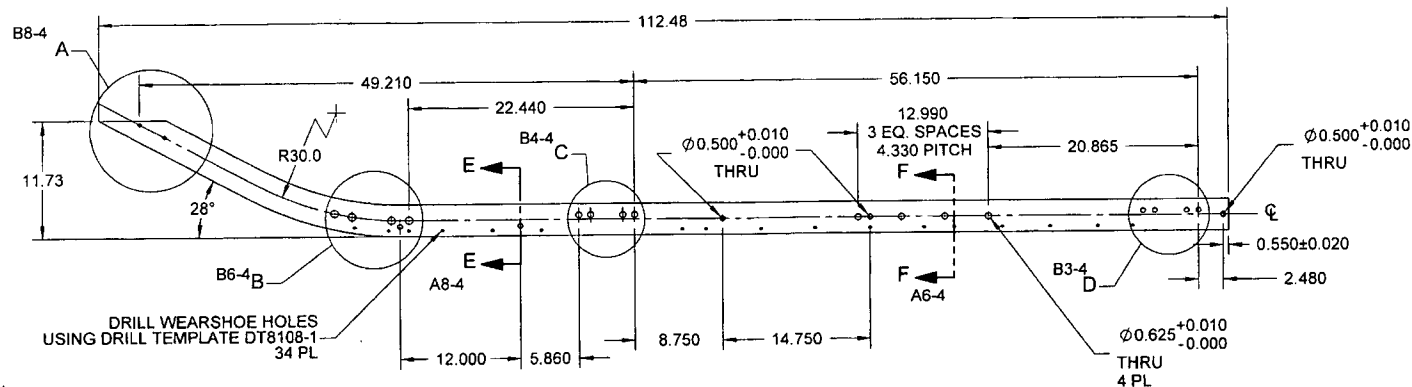
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

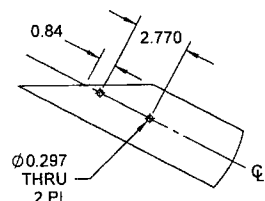
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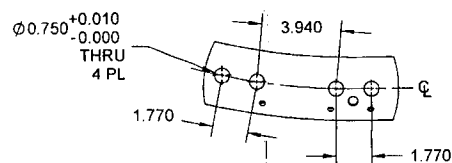
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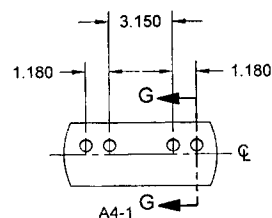
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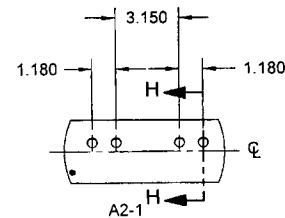
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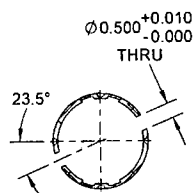
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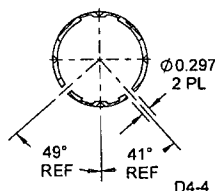
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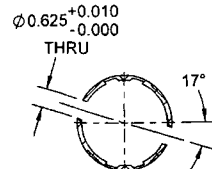
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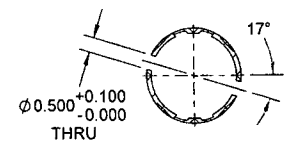
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SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
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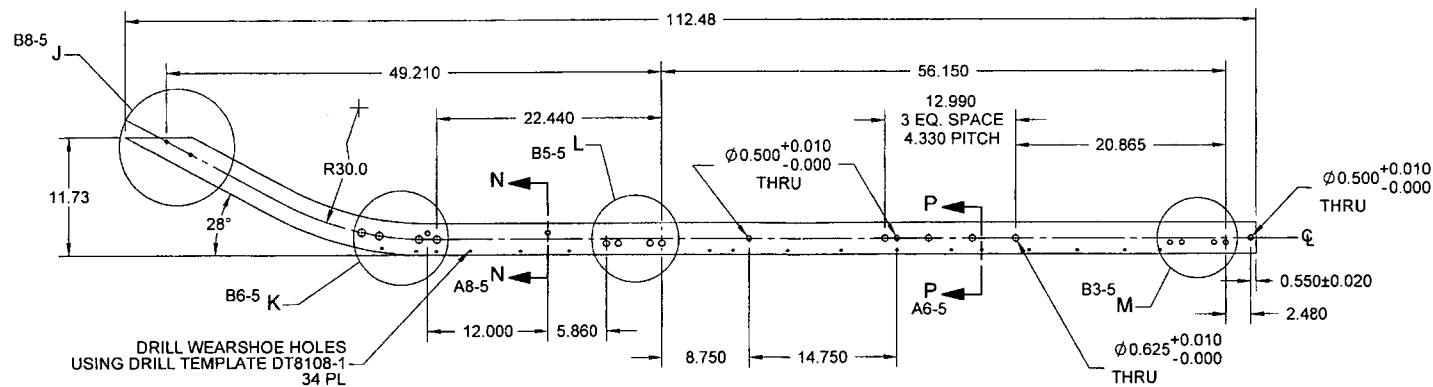


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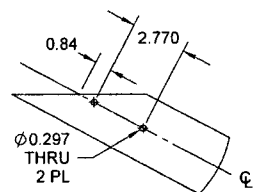
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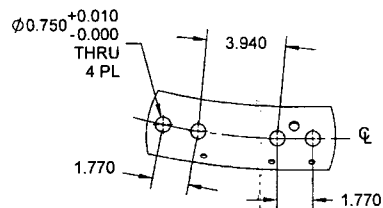
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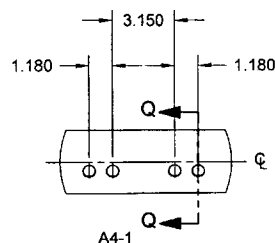
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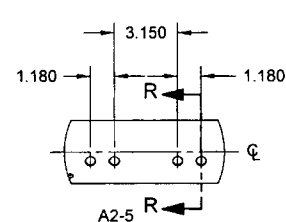
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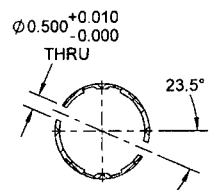
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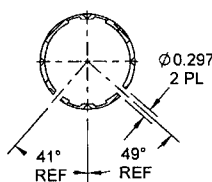
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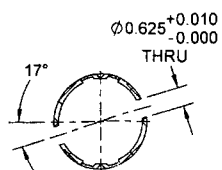
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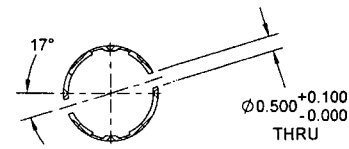
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
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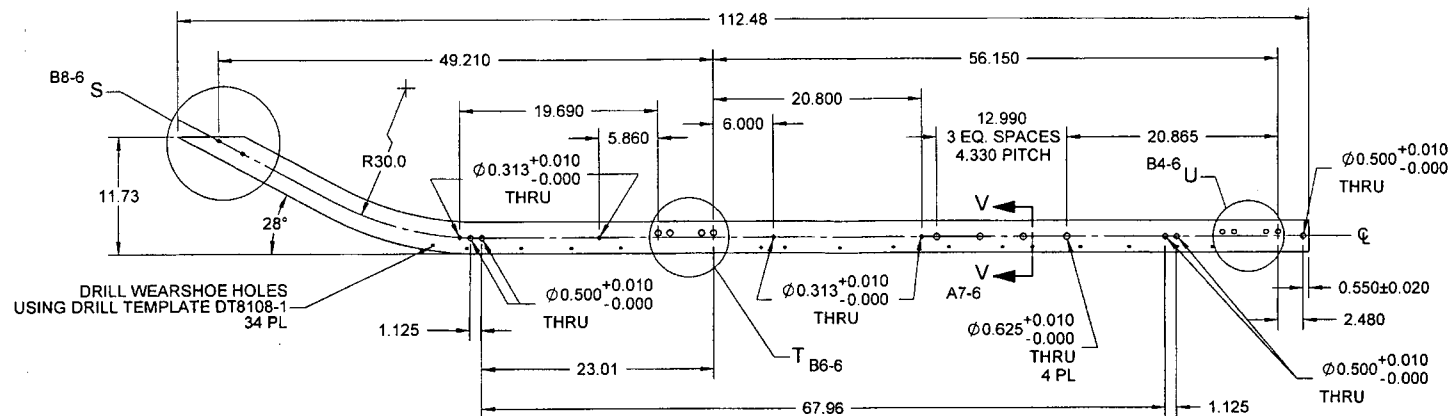
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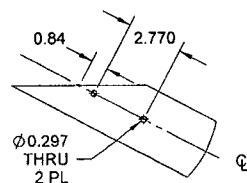
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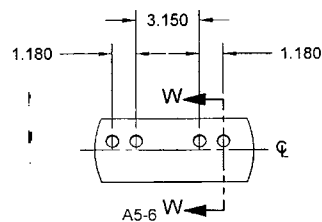


D2750-3 LH SKIDTUBE

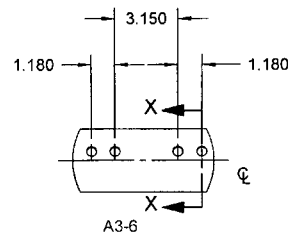
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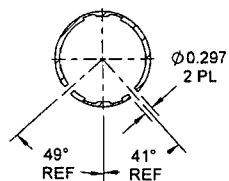
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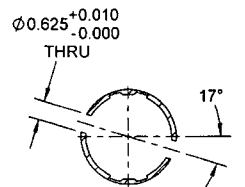
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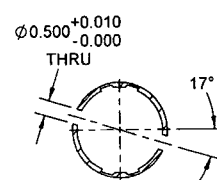
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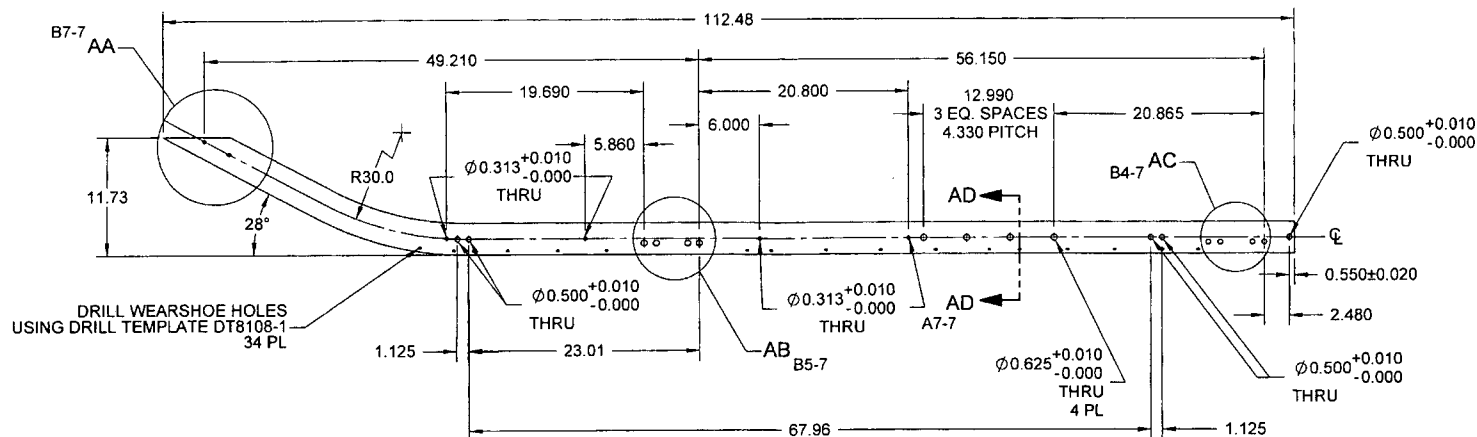
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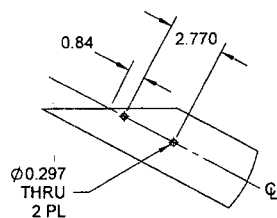
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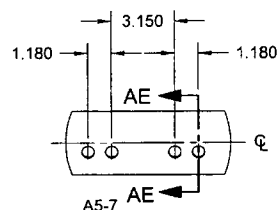
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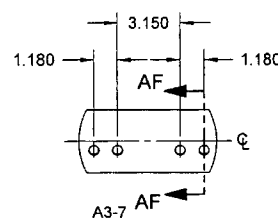
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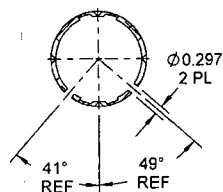
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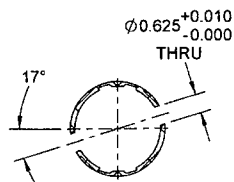
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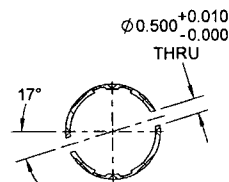
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SCALE 3X, 17 PL



SECTION AE-AE
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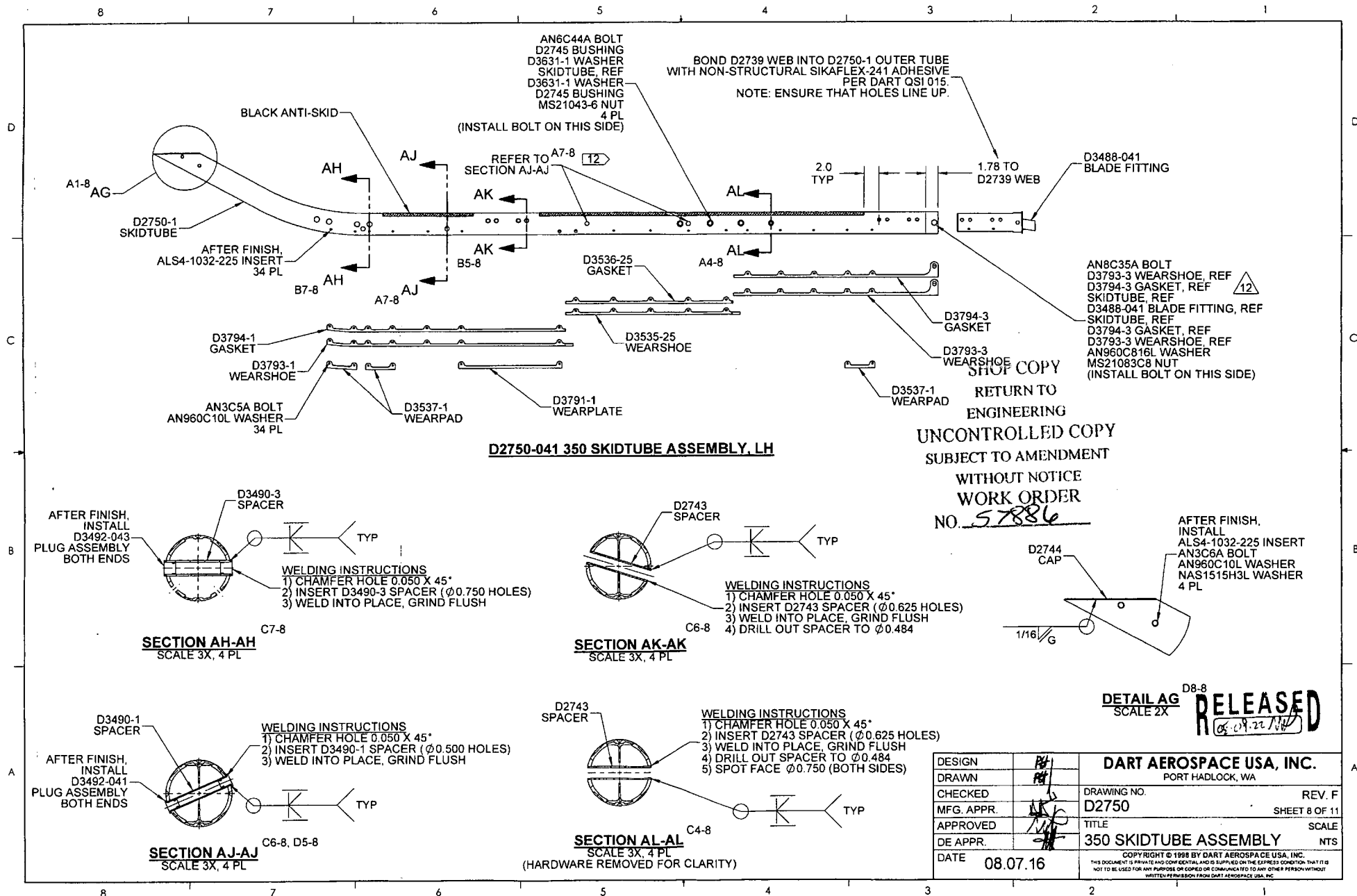


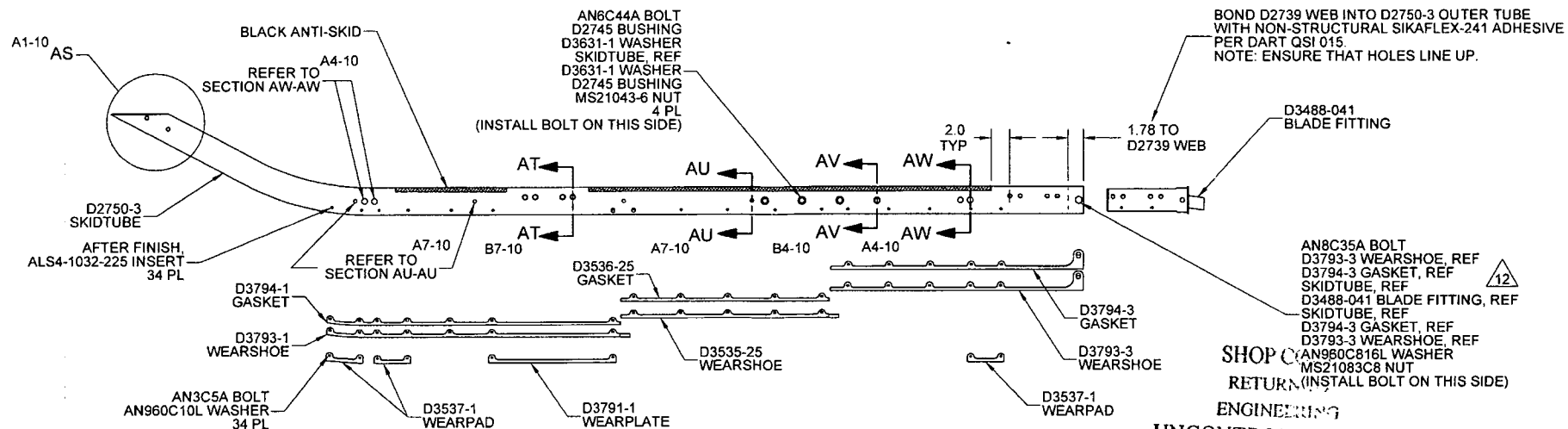
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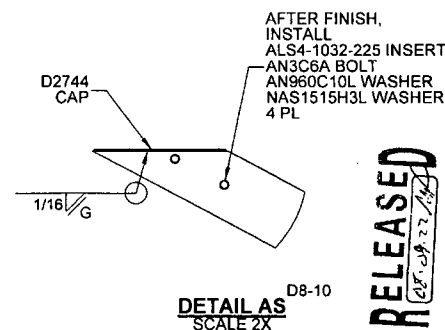
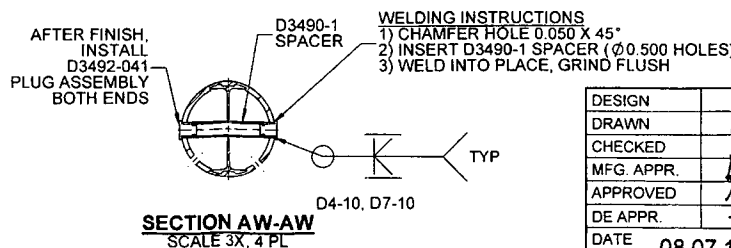
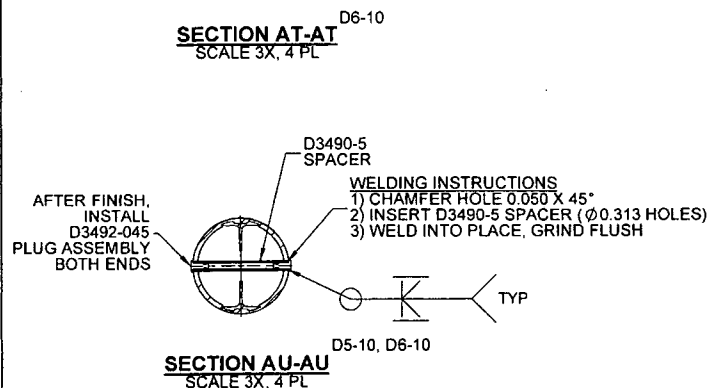
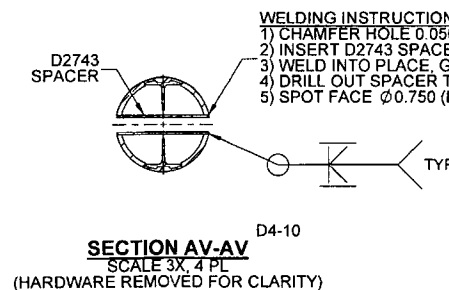
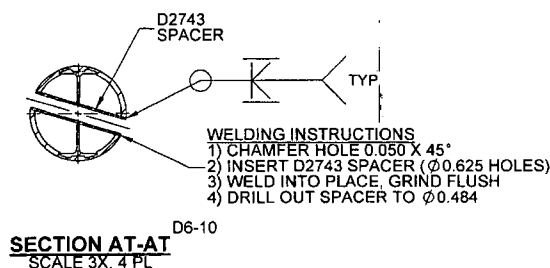
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

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RELEASED
08.07.16

NO. 225

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56276
Part number: D-50-63-013
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. D. A. Date of Test Coupon 10.02.19

Welder Barclay Elliott Date of Test Coupon 16.02.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld